

[illegible]

October 22, 2009 3:50:17 PM

**Accept**

Setup	Start
-------	-------

## Start

**Stop**

**Item Name:** Spacepod Door, RH

**Start Date:** 21/10/2009 **Start Qty:** 1.00

**Cust Item ID:**

**Required Date:** 04/11/2009    **Req'd Qty:** 1.00

**Customer:**

**Reference:**

## Run

## Start

**Approvals:**

**Process Plan:**

Date: 09-10-22

**Tooling:**







**Date:**

**QC:**

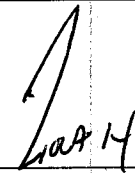
Date:

**SPC (Y/N):**

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3186	Rev E								
100		0.00							
	Small Fab								
Small Fab	<b>Memo</b>	0.00							
Small Fab	1-Drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail)								
110		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	<b>Memo</b>	0.00							
Quality Control									
120		0.00							
	Identify as per dwg & Stock Location: <u>Composites</u>								
Packaging	<b>Memo</b>	0.00							
Packaging									 10-07-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-07-14	100	1-Trim door as necessary to fit specified opening  Permanent change	BT	10-07-14		 10/07/14	S 10/07/14

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 53084**

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Page 2

Item ID: D3186-4

Accept



Setup

Start



Revision ID: E

Stop



Item Name: Spacepod Door, RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run

Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*100A-14**10-7-14*  
*①*

# Picklist Print

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Page 1

Work Order ID: 53084

Parent Item: D3186-4RevE

Parent Item Name: Spacepod Door, RH



Start Date: 21/10/2009

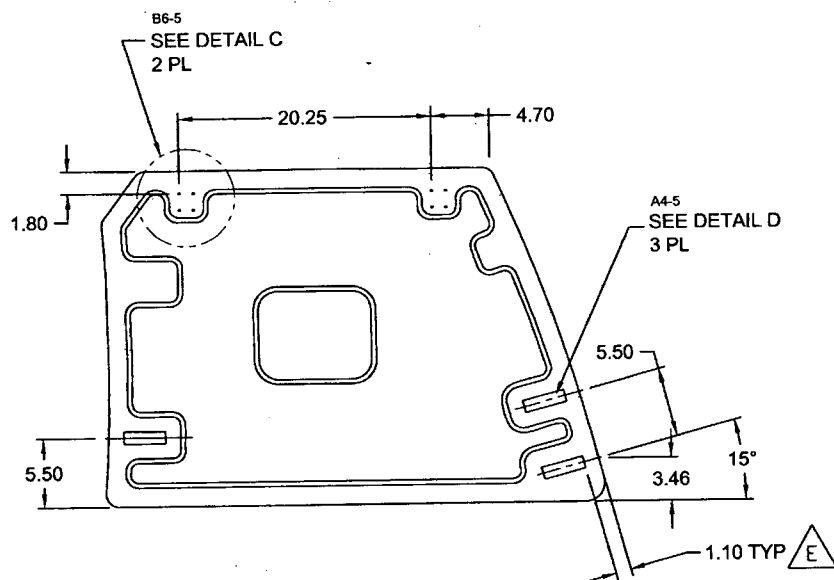
Required Date: 04/11/2009

Comments:

Start Qty: 1.00

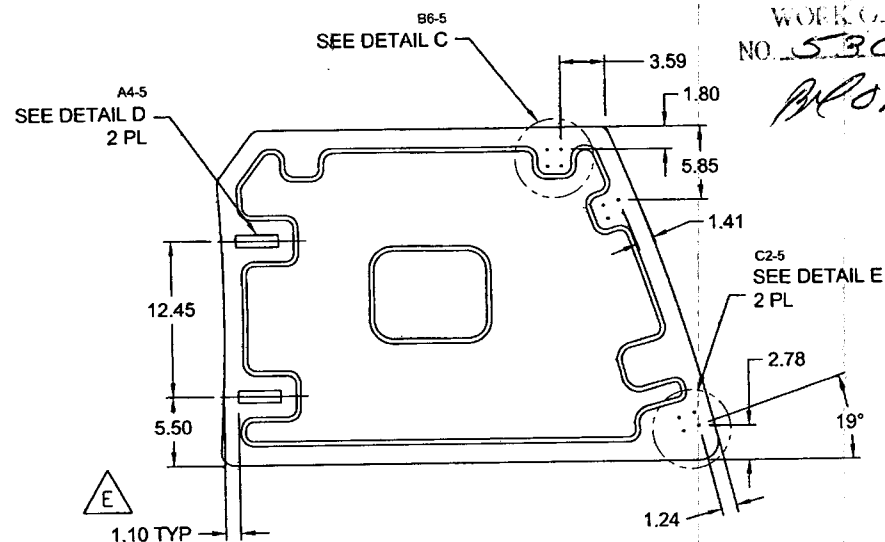
Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3186-2MRevE		Manufactured	No			100	Each	0.0000	1.0000			
 SPACEPOD DOOR RH										<i>25</i>	<i>10-07-13</i>	



**D3186-1 SPACEPOD DOOR, LH**  
MAKE FROM D3186-1M

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: NONE  
7) WEIGHT: N/A

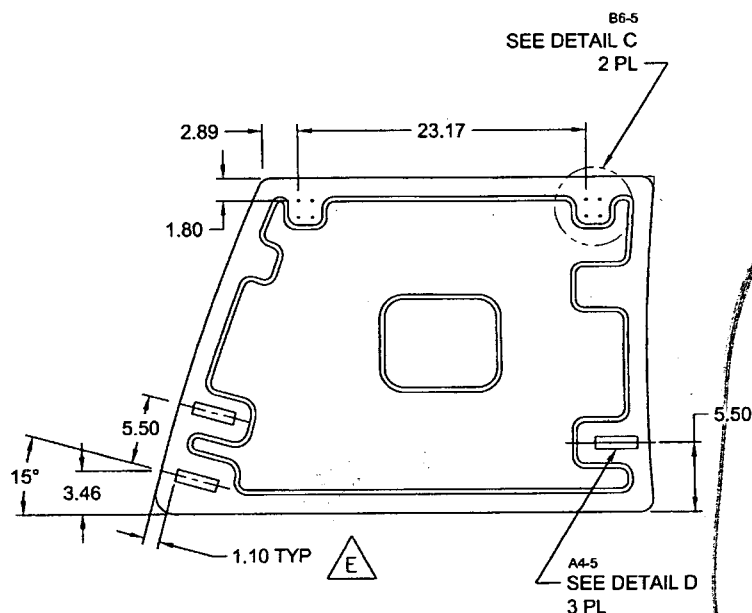


**D3186-3 SPACEPOD DOOR, LH**  
MAKE FROM D3186-1M

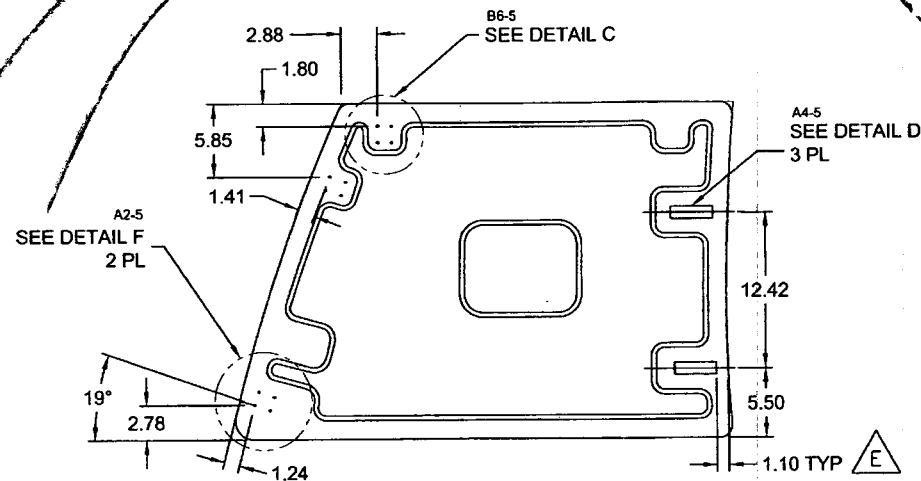
**RELEASED**  
2009-09-09

REV.	DESCRIPTION	BY	DATE
E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M-2M-3-4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JP	DRAWING NO.	REV. E
MFG. APPR.	JP	D3186	SHEET 1 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

53084



**D3186-2 SPACEPOD DOOR, RH**  
MAKE FROM D3186-2M



**D3186-4 SPACEPOD DOOR, RH**  
MAKE FROM D3186-2M

**RELEASED**  
2009-09-09

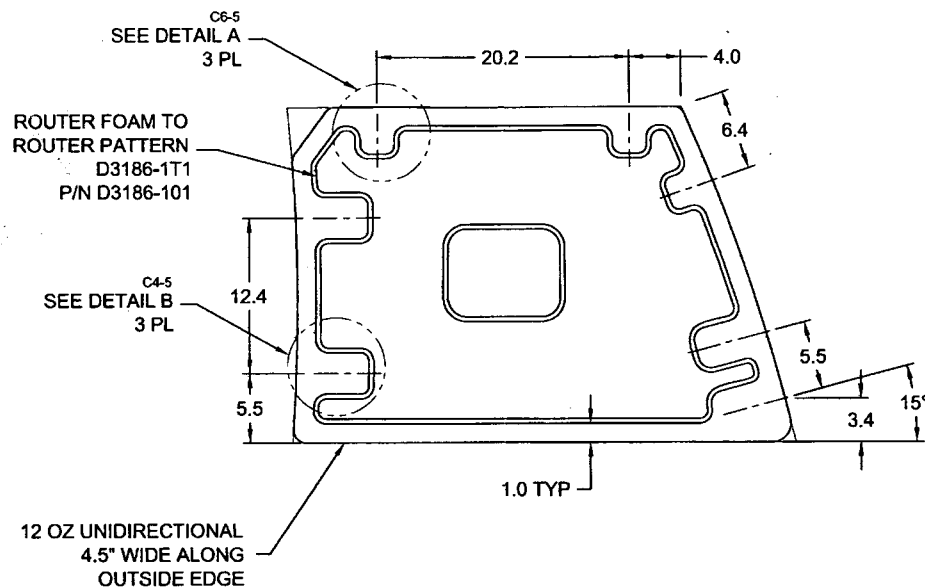
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
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53089

MAIN LAYUP  
9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY



**D3186-1M SPACEPOD DOOR AS MOLDED**

**NOTES:**

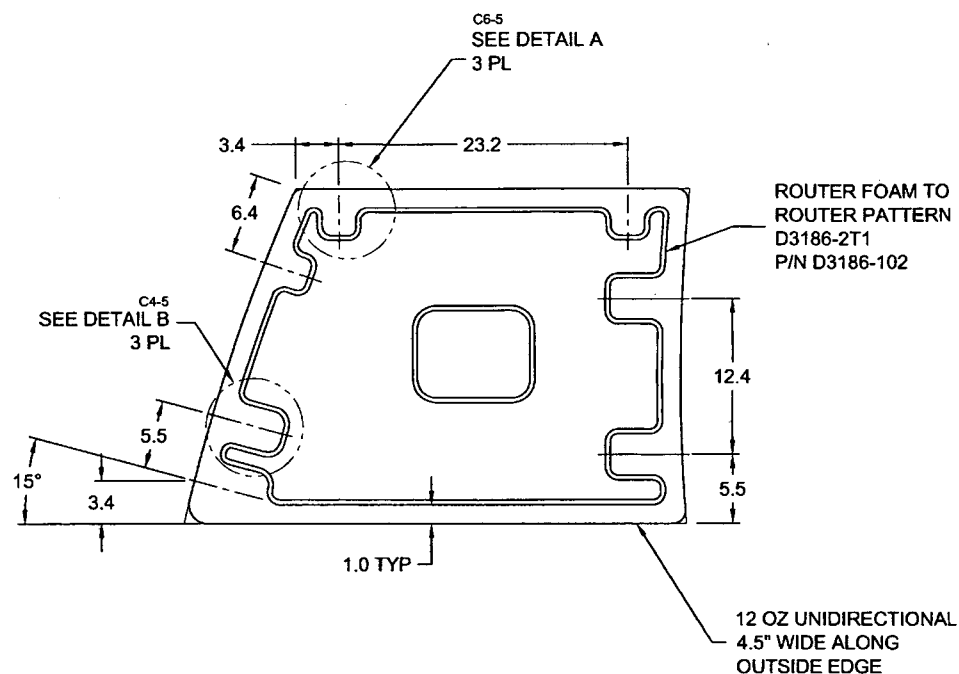
- 1) MATERIAL:  
RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL  
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
LAMINATE PER DART QSI 006 4.0  
LAMINATION SCHEDULE PER THIS DRAWING
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.0 lbs
- 8) USE MOLD DT8005 FOR DOOR LAYUP

**RELEASED**  
2009-08-08

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MFG. APPR.		D3186	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
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# MAIN LAYUP

9 OZ SATIN (9 SQ FEET)  
 9 OZ SATIN (9 SQ FEET)  
 FOAM  
 9 OZ SATIN (9 SQ FEET)  
 12 OZ UNIDIRECTIONAL  
 9 OZ SATIN (9 SQ FEET)  
 RESIN (35-45% BY WEIGHT)  
 PEEL PLY



**D3186-2M SPACEPOD DOOR AS MOLDED**

## NOTES:

### 1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
 FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL  
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
 LAMINATE PER DART QSI 006 4.0  
 LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

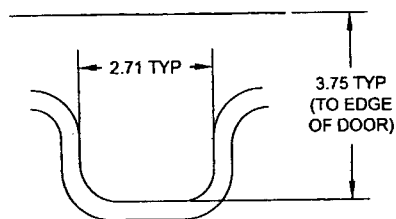
8) USE MOLD DT8006 FOR DOOR LAYUP

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 2009-08-09

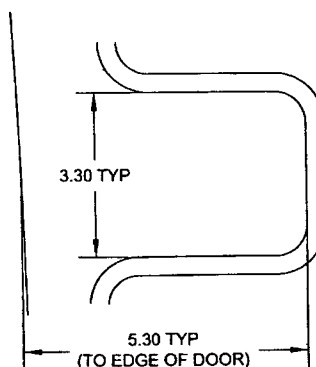
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MFG. APPR.		D3186	SHEET 4 OF 5
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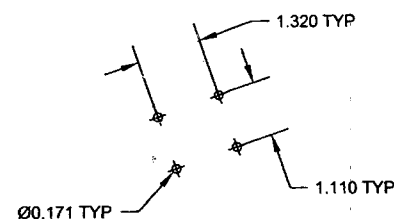
53084



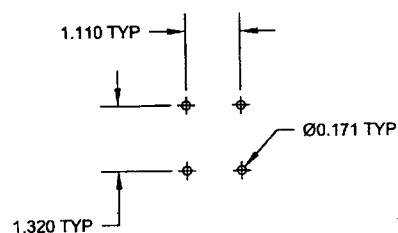
**DETAIL A** D6-3  
SCALE 4X D4-4



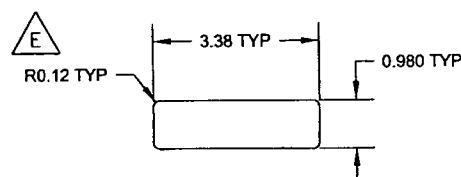
**DETAIL B** C6-3  
SCALE 4X C6-4



**DETAIL E** C1-1  
SCALE 4X

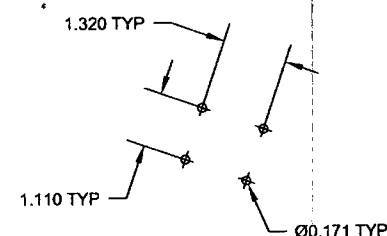


**DETAIL C** D7-1  
SCALE 4X D3-1  
D6-2  
D3-2







NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D** C5-1  
SCALE 4X D4-1  
B6-2  
C2-2



**DETAIL F** C4-2  
SCALE 4X

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2009-09-09

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